∾Date: User: Thursday, 16/10/2008 10:45:41 AM

Julie Dawson

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 42631 : 10313

Estimate Number P.O. Number

This Issue

: 16/10/2008 : NC

Prsht Rev.

First Issue **Previous Run**

: // : 42361 Type

S.O. No. :

: SMALL /MED FAB

Part Number

Drawing Name

: D26483 : D2648 REV D

Drawing Number Project Number

: N/A : D

: WEARPAD

Drawing Revision

Material

Due Date

: 31/10/2008

Qty:

40 Um:

Each

Checked & Approved By

Comment

Written By

: Est: E 02.09.18

Re-format; Incorporated D2648-1 KJ/RF Est Rev:F

Now on Waterjet 06-08-14

JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1010/1025 sheet 16GA

1.0

M1010S16GA

Comment: Qty.: 0.0788 sf(s)/Unit Total:

3.1500 sf(s)

1010/1025/A21/6aA SHEET

(M1010S16GA)

Batch: 105

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2648

Dwg Rev:__

188-11-6





2-Deburr if necessary

138-11-6

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IR 8-116

SECOND CHECK

4.0

Comment: SECOND CHECK

5.0

SMALL FAB 1

SMALL & MEDIÚM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary





Dart Aerospace Ltd

W/O:			WOF	RK ORDER CHANG	ES			4	
DATE	STEP	PROC	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	*								
							-		
*		100							
Part No	•	PAR #:	_ Fault Catego	ory:	NCR: Yes	s No DQ	A:	Date:	
Resolution:		esolution:	_ Disposition:	-	QA: N/C Closed:			Date:	
NCR:		W	ORK ORDE	R NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		orrective Action Secti		Verifi	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da		ion C	Chief Eng	QC Inspector
						,			
				1					

NOTE: Date & initial all entries

Thursday, 16/10/2008 10:45:41 AM User: Julie Dawson **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: WEARPAD** Job Number: 42631 Part Number: D26483 Job Number: Seq. #: Description: Machine Or Operation: 6.0 BRAKE NC NC BRAKE Comment: NC BRAKE 1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D2648-3 LARGE FABRICATION RESOURCE 1 LARGE FAB 1 7.0 Comment: LARGE FABRICATION RESOURCE 1 Batch Qty Description M109560 A/R560Hardcoat 1-Weld as per Dwg D2648 using Jig DT 8210 2-Remove any weld that penetrated through Wearpadif necessary VISUAL INSPECTION OF GROUND WELDS 8.0 QC10 Comment: VISUAL INSPECTION OF GROUND WELDS INSPECT WORK TO CURRENT STEP 9.0 QC5 TO CURRENT STEP POWDER COATING 10.0 POWDER COATING 06442 Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 START TIME: OVEN TEMPERATURE: FINISH TIME: INSPECT POWDER COAT/CHEMICAL CONVER 11.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 12.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:

Dart Aerospace	Ltd
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	- CP MOO								
W/O:			W	ORK ORDER CHANGE	ES	i i			
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	101	PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	_ Date: _	
Part No:	esolution:	Disposition: QA: N/C Closed:					Date:		
NCR:			WORK ORI	DER NON-CONFORMA	NCE (NCR)			
DATE	CTED	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DAIE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Chief Eng	QC Inspector
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NOTE: Date & initial all entries

Date: User: Thursday, 16/10/2008 10:45:41 AM

Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 42631

Part Number: D26483

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:			V	ORK ORDER CHANG	SES					
DATE	STEP	PROC	EDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							1			
										·
Part No	•	PAR #:	_ Fault Ca	tegory:	_ NC	R: Yes	No DQ	A :	_ Date: _	
Resolution:		esolution:	Disposition: Q			QA: N/C Closed:			Date:	
NCR:		W	ORK OR	DER NON-CONFORM	ANCE	(NCF	₹)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng	tion B	Sign &	& Secti	cation on C	Approval Chief Eng	Approval QC Inspector
·				Onlor Eng				1		
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										,

NOTE: Date & initial all entries

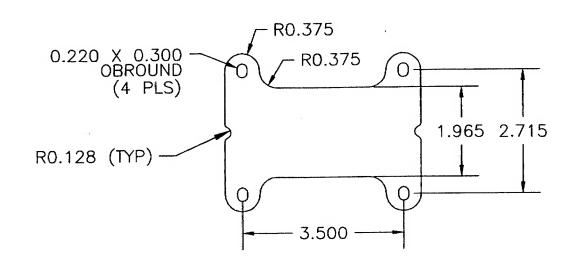
DART AEROSPACE LTD	Work Order:	42031
Description: Wearpad	Part Number:	D2648-3
Inspection Dwg: D2648 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

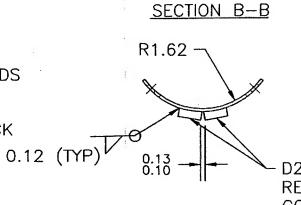
(1)	x	First Articl		Protot			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method o		nments
1.965	+/-0.010	1,966	K				
2.715	+/-0.010	2,713	×				
3.500	+/-0.010	3,491	N.				
0.220 x 0.300	+/-0.010 x +/-0.010	705,X KG	3 2				
R0.375	+/-0.010	375	>				
R0.128	+/-0.010	861.	<i>*</i> 0				-
		1(00					
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			-				
							
	1						

		-					
				 	l		
Measured by:	B	Audited by:			Prototyp	N/A	
Date:	8-11-6	Date:	108.11	·ot		Date:	N/A
Rev Date	Change					Revised by	Approved
A 06.10.1					_	KJ/JLM	Approva

D2648-1 FLAT PATTERN

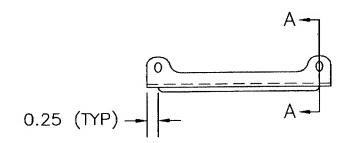


R1.62 7560 HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.063 TO 0.125 THICK

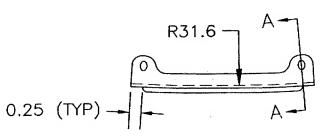


D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

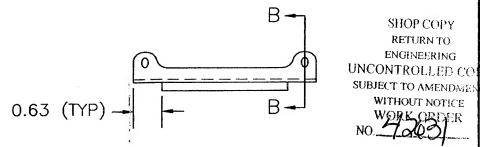
D2648-3 LONGITUDINAL BEND (MADE FROM D2648-1)

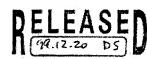


D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



(MADE FROM D2648-1)







D	99.11.17	ADDED D2648-7
С	, 97.06.26	R31.6 WAS R19.6
В	97.05.30	ENLARGE OBROUND, 0.375 WAS 0.250
Α	97.03.25	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO. REV. D D2648 SHEET 1 OF 1
DATE	1,7	TITLE SCALE
99:11.17		WEARPAD 1:2

BREAK ALL SHARP CORNERS 0.063 MAX

MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)

FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES